Date: User: Job Number Prsht Rev. First Issue Previous Run Written By Comment

Tuesday, 2/26/2008 8:02:10 AM

Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

: 37631 **Estimate Number** : 10729

P.O. Number

This Issue : 2/26/2008

: 36749B

: NC : //

S.O. No. :

: SMALL /MED FAB Type

Part Number **Drawing Number**

Drawing Name

: D23245 : D2324 REV C

: STRAP

Project Number

: N/A : C

Drawing Revision Material

Due Date

: 3/17/2008

Qty:

50 Um:

Each

Checked & Approved By

: Est. E 03.92.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

Additional Product

Job Number:



0.0184 sf(s)/Unit

Seq. #:

Machine Or Operation:

Description:

1.0 M304S16GA



Total:

0.9200 sf(s)

304/316 .063 Sheet

106860

2.0 WATER JET

304/316 .063 Sheet



Comment: FLOW WATER JET

1-Cut as per Dwg D2324

Dwg Rev: ________

Prog Rev: C

2-Deburr if necessary

QC2

Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

4.0

3.0

QC8

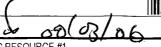
SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING





PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				g		i		
		•	, , ,					
· .				·				

Part No: D334-5 PAR #: NA Fault Category Polific Past NCR: Ves No DQA: Date: 08/03/10

WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval** Approval QC Inspector **STEP** DATE Sign & Initial **Action Description** Section A Section C Chief Eng Date Chief Eng 爱 08/08/06

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:10 AM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STRAP Job Number: 37631 Part Number: D23245 Job Number: Seq. #: Machine Or Operation: Description: 6.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE 2008/3/07 Job Completion

Dart Aerospace Ltd

_									
W/O:			WC	ORK ORDER CHANG	ES				
DATE STEP		PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								:	
								ļ	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ /	\ A :	Date:	
								Date: _	:
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	₹)		į	
DATE	STEP	Description of NC Section A	Initial Action Description		n B Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
								1	
				•				i	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3763
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension Actual Dimension Accept Reject Method of Inspection Comment			_				
Ø0.257 +0.006/-0.001 JSQ Ø0.191 +0.005/-0.001 JQJ 0.750 +/-0.010 JSI 0.375 +/-0.010 JSI 1.875 +/-0.010 JSI 3.000 +/-0.010 JSI 3.375 +/-0.010 JSI		Tolerance	1	Accept	Reject	Method of Inspection	Comments
Ø0.191 +0.005/-0.001 193 0.750 +/-0.010 335 0.375 +/-0.010 335 1.875 +/-0.010 1.875 3.000 +/-0.010 3,000 3.375 +/-0.010 3,375	R0.38	+/-0.030	.38	-			
0.191	Ø0.257	+0.006/-0.001	259	X			
0.750	Ø0.191	+0.005/-0.001	_				
0.375 +/-0.010 335 4 1.875 +/-0.010 1.875 4 3.000 +/-0.010 3,000 4 3.375 +/-0.010 3,375 4	0.750	+/-0.010	1				
1.875	0.375	+/-0.010					
3.000 +/-0.010 3.000 ± 3.315 ±	1.875	+/-0.010		·L			
3.375 +/-0.010 3,315	3.000	+/-0.010					
	3.375	+/-0.010	3,375	¥			
					•		
					711		to Mineral Line

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		1					

Measured by:	J.B	Audited by:		Prototype Approval:	N/A
Date:	8-3-4	Date:	00/03/06	Date:	N/A

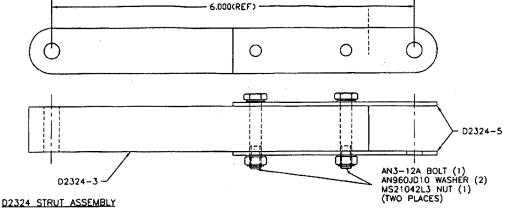
Rev	Date	Change	Revised by	Approvéd
Α	06.06.05	New Issue	KJ/JLM A	



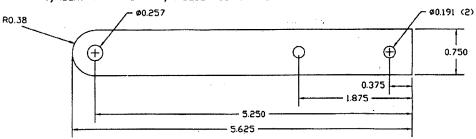
DESIGI B W	N IILLIAMS	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,			
CHECK		APPROVED .	DRAWING NO.	7	REV.	С
	#	-#-	D2324	SHEET	1 OF	1
DATE			TITLE		SCA	NLE
04.1	2.14		STRUT			
Α		94.11.08	NEW ISSUE	,		
В		96.05.07	UPDATE MATERIALS			

RELEASED

04.12.14 UPDATE NOTES С



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

(REF DART SPEC. M6061T6B0.750X00.750)

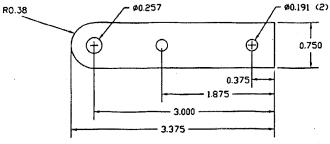
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA) 1) MATERIAL:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0:005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SP .(G ? COba UNCO LINT RE I NOTICE